

# Work Order ID 60056

June 24, 2010 7:38:49 AM



Page 1

Item ID: D2196-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 6/24/10

Start Qty: 2.00



Cust Item ID:

Required Date: 6/28/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CX

Date: 10/6/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2196

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

6061 .500 x 5"

B 10-6-24

2

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-6-24

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Solooby

62

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-open hole to finish size as per dwg □ 2- deburr

⇒ m.d 10/06/25

2X

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S 206615

72

150



HandFinish

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

Hand Finishing

94 10/06/21

42

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 60056**

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Item ID: D2196-3

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Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 6/24/10

Start Qty: 2.00

Cust Item ID:

Required Date: 6/28/10

Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 10-6-28

170

Identify as per dwg &amp; Stock Location:

008

0.00



Packaging

Memo

0.00

Packaging

10/6/28 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28  
mf 10-6-28

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 7:38:48 AM

Page 1

Work Order ID: 60056



Parent Item: D2196-3



Parent Item Name: Spacer

Start Date: 6/24/10

Required Date: 6/28/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No			100	f	52.4036	0.351	0.738947			



6061-T6 Bar .500 x 5.00



H3 10-6-24

Location

Loc Qty

Loc Code

MAT03

52.4036

112041

20

112154

32.4036

②

112154

W/O:			WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

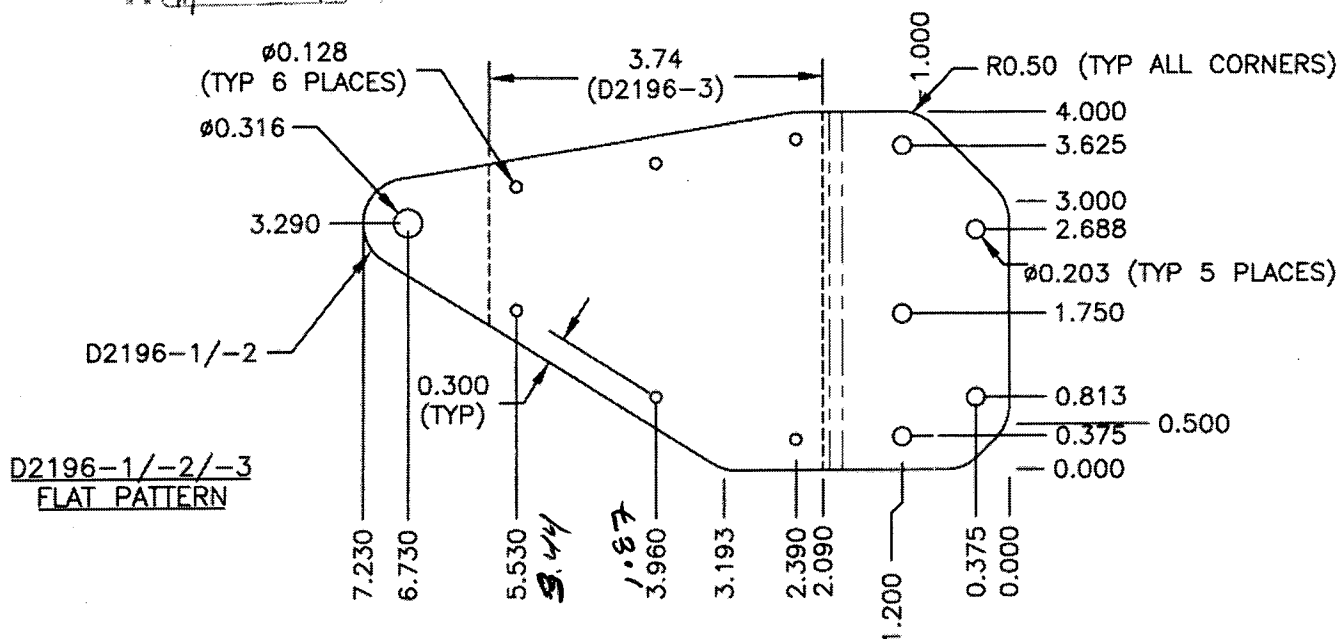
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN	<i>#</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D2196 REV. C SHEET 1 OF 1
DATE	03.05.28	TITLE	BRACKET	SCALE 1:2
B	93.09.23	REDESIGN		
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK		

**RELEASED**  
*03.07.09***D2196-1/-2**

- 1) MATERIAL: AISI 304/316 S.S.  
0.064" THICK (M304S16GA)

**D2196-3**

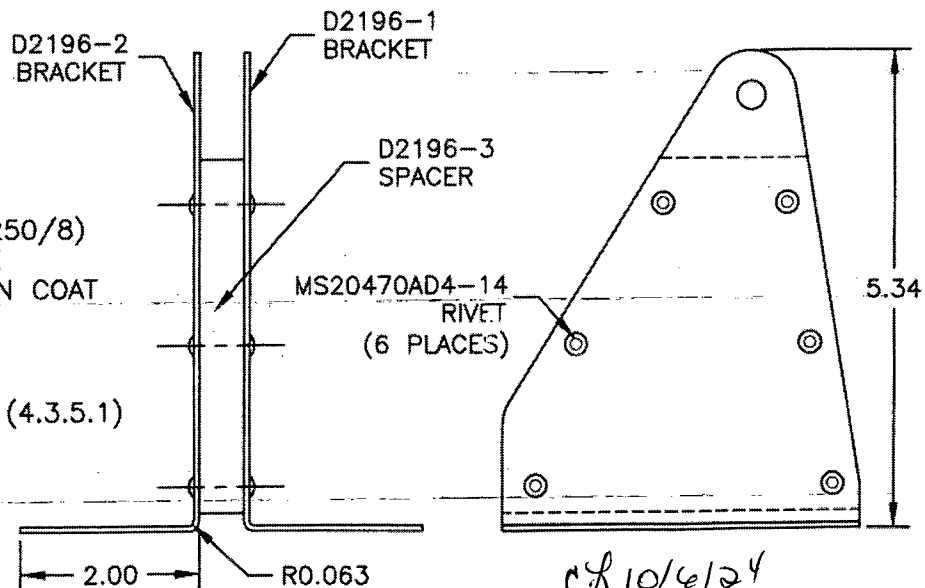
- 2) MATERIAL: 5052H32 (QQ-A-250/8)  
0.500" THICK 4x0.125 THICK  
3) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1

**D2196 BRACKET (ASSEMBLY):**

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)  
PER DART QSI 005 4.3

**GENERAL NOTES:**

- 5) ALL DIMENSIONS ARE IN INCHES  
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
7) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D2196 BRACKET  
(ASSEMBLY)***cX10/6/24*  
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